

shp Jan. 31

Work Order ID 79375

\*79375\*

Wednesday, January 25, 2012 11:50:30 AM

Item ID: D4434-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 1/25/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

1/20/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4434	A								
100	FLOW WATER JET	0.00							
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D4434-6 as per Dwg								
6061. 040	Dwg Rev: A								
	Prog Rev: A								
	2-Deburr if necessary								(2)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

B12-1-26

B12-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 79375****\*79375\***

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Bracket

Start Date: 1/25/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		8/12/14/26		(72)			
130 <b>*130*</b> Brake NC Brake NC	Bend as per dwg  Memo	0.00 0.00		SP 12/10/1/26		(2)			
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		8/12/10/1/27		(72)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 79375

**\*79375\***

Page 3

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 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 1/25/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 2/3/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*160*</b>						2			
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
190	Black Sandtex(Ref 4 3.5.7) per QSI005 4.3	0.00							
<b>*190*</b>									
Powdercoat	Memo	0.00							
Powder Coating									

2X PM 12/31/30

12.01.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 79375****\*79375\***

Page 4

Wednesday, January 25, 2012 11:50:30 AM

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Revision ID: Stop **\*NS2\***  
Item Name: Bracket  
Start Date: 1/25/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 2/3/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00							
<b>*200*</b> QC Quality Control	Memo	0.00							
210	Identify as per dwg & Stock Location <u>GA</u>	0.00							
<b>*210*</b> Packaging Packaging	Memo	0.00							
220	QC21- Final Inspection - Work Order Release	0.00							
<b>*220*</b> QC Quality Control	Memo	0.00							

12/1/30  
②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, January 25, 2012 11:50:35 AM

Page 1

Work Order ID: 79375

\*79375\*

Parent Item: D4434-3

\*D4434-3\*

Parent Item Name: Bracket

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased		No			sf	330.9100		0.55			
*M6061T6S 040*									**			B12-1-26	
6061-T6 .040 Sheet													

### Location

### Loc Qty

### Loc Code

MAT021

330.91

113004

2.5

117653

40.91

120154

95.5

120218

192

120718

(2)

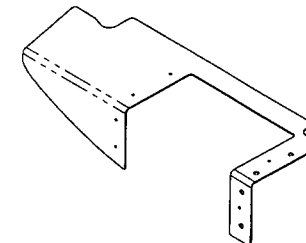
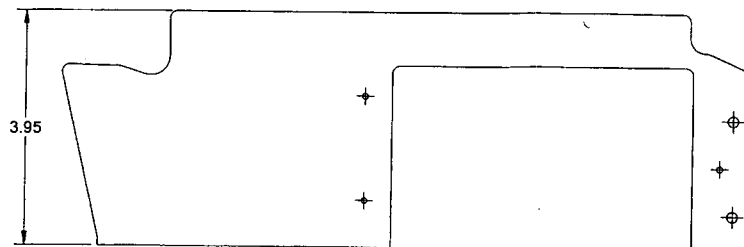
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

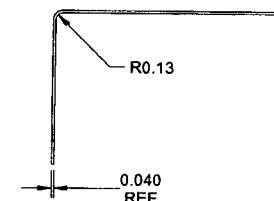
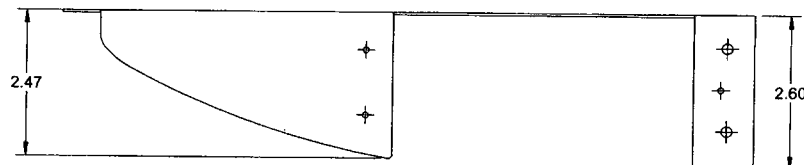
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



SHOP COPY  
RETURNED  
ENGINEER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 19375  
PL12-01-28



# **D4434-3 BRACKET**

## **NOTES:**

- 1) MATERIAL: MAKE FROM D4434-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4434</b>	SHEET 8 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>COVER ASSEMBLY</b>	NTS
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2012-01-23  
*[Signature]*

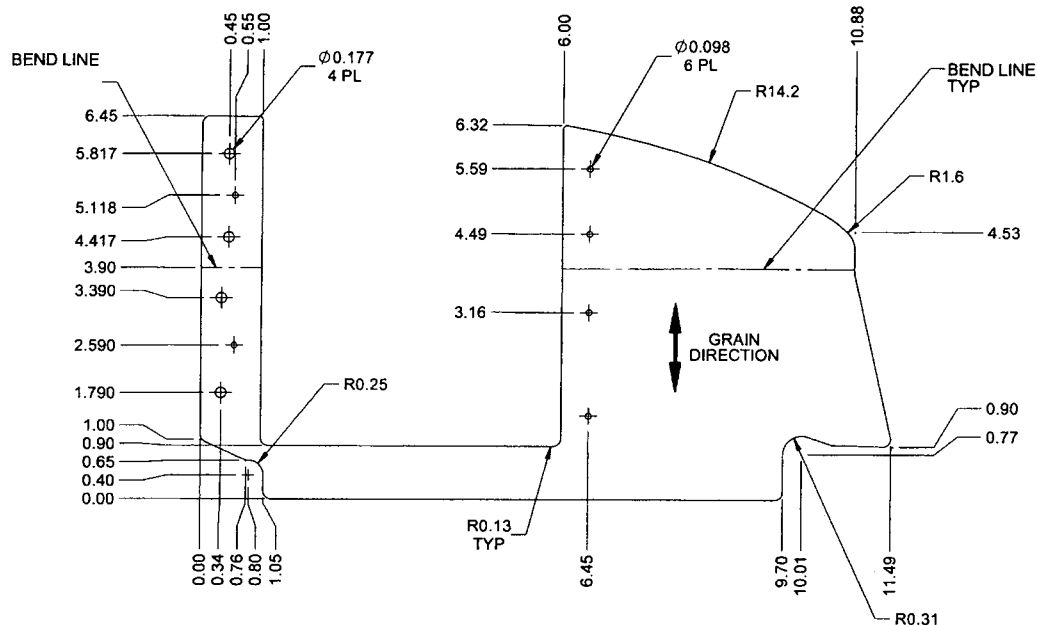
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D4434-3F FLAT PATTERN**

## **NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4434</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 9 OF 15	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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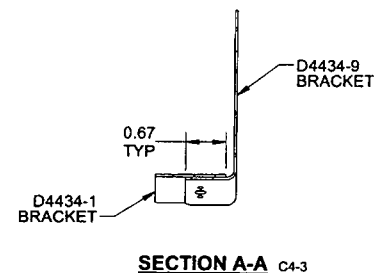
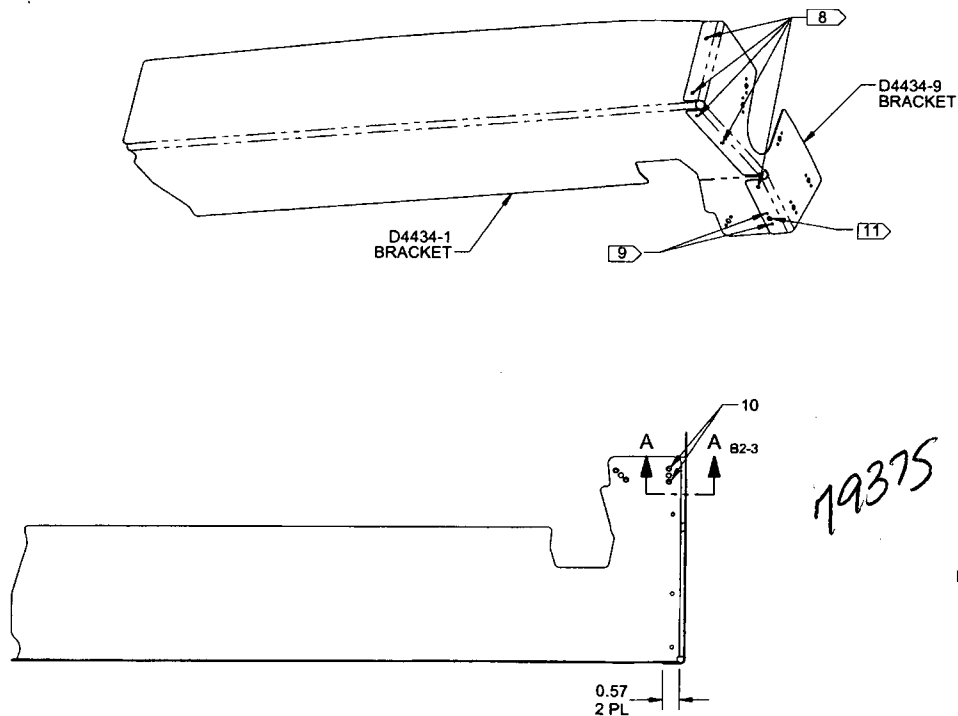
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







**D4434-043 FWD INBOARD BRACKET ASSEMBLY  
AUXILIARY VIEW**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.04 lbs
- 8) TRANSFER  $\varnothing 0.129$  HOLES THRU 5 PLACES FROM D4434-9 TO D4434-1
- 9) TRANSFER  $\varnothing 0.098$  HOLES THRU 2 PLACES FROM D4434-9 TO D4434-1
- 10) CSK  $\varnothing 0.179 \times 100^\circ$  ON THIS SIDE 2 PLACES
- 11) TRANSFER  $\varnothing 0.177$  HOLE THRU FROM D4434-9 TO D4434-1

**RELEASED**  
2012-01-23

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4434</b>	SHEET 3 OF 15
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DE APPR.		<b>COVER ASSEMBLY</b>	NTS
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DART AEROSPACE LTD		Work Order: 79379	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article     ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.099	2		V	B02
Ø .177	+ .004 - .001	.179	2		V	
1.790	± .010	1.795	2		V	
2.590	± .010	2.596	2		V	
3.390	± .010	3.389	2		V	
4.417	± .010	4.419	2		V	
5.118	± .010	5.119	2		V	
5.817	± .010	5.817	2		V	
6.45	± .030	6.450	2		V	
3.16	± .030	3.164	2		V	
4.49	± .030	4.489	2		V	
5.59	± .030	5.590	2		V	
6.32	± .030	6.326	2		V	
.96	± .030	.920	2		V	
.34	± .030	.340	2		V	
.45	± .030	.449	2		V	
.55	± .030	.556	2		V	
1.06	± .030	1.003	2		V	
6.08	± .030	6.004	2		V	
9.70	± .030	9.698	2		P	Prow302
11.49	± .030	11.49	6		P	
1040	± .010	1038	2		V	

Measured by: B	Audited by: S	Prototype Approval:
Date: 12-1-26	Date: 12/01/26	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	